User:

Friday, 11/18/2005 5:31:36 PM

Linda Lacelle

**Process Sheet** 

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 24878

**Estimate Number** 

: 10299

P.O. Number

This Issue Prsht Rev.

Written By

: N/A-

: 11/18/2005

: NC

: NIA First Issue

**Previous Run** 

: NIA

S.O. No. : NIA

**PURCHASED PARTS** 

ABOUR USER & NATE

Checked & Approved By Comment

F 02.09.24 Re-format KJ/RF : Est:

: SEE COMMENT BELOW

Part Number **Drawing Number** 

Material

**Drawing Name** 

: D25775 - D2577 REV E : NIA

Project Number **Drawing Revision** 

: E : NIA

**Due Date** 

: 12/15/2005

051122

: WEARPLATE

Qty:

50 Um:

Each

**Additional Product** 

Job Number:



Seq.#:

Machine Or Operation:

Description: PURCHASING

1.0

PG



Comment: PURCHASING

Issue P/O: 146

Email or Ship DXF file to vendor

Laser Cut per Dwg D2577 flat pattern D2577-5

Material release note required

2.0 D25775F Wearplate, Centre



WEAR PLATE FWD

1.0000 U(s)/Unit Tótal: Comment: Qty.:

50.0000 U(s)

**PACKAGING 1** 

**PACKAGING RESOURCE #1** 

W



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material release note is attached

4.0

QC6

DIMENSIONAL CHECK

3.0



Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2577-5T1

5.0

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr



Page 1

Form: rprocess

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NOTE: Date & initial all entries

Friday, 11/18/2005 5:31:36 PM Date: User: Linda Lacelle **Process Sheet** Drawing Name: WEARPLATE Customer: CU-DAR001 Dart Helicopters Services Part Number: D25775 Job Number: 24878 Job Number: Description: Seq. #: Machine Or Operation: BRAKE NC NC BRAKE 6.0 Comment: NC BRAKE 1-Form on brake using DT8155 and DT8179 as per Dwg D2577 2-Form joggle using DT8157 as per Dwg D2577 3-Identify as D2577-5 INSPECT WORK TO CURRENT STEP QC5 7.0 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING 8.0 POWDER COATING Comment: POWDER COATING DL Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 9.0  $\mathfrak{m}'$ Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 10.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 1. DOCUMENT CONTROL 11.0 DC Comment: DOCUMENT CONTROL Inspection Level 21 W 06. B. 22 Job Completion

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NOTE: Date & initial all entries

## 

## Job Costing Report

Dart Aerospace Ltd. Nov 18, 2005 Hawkesbury 09:21 am

Work Order No : 0024878
Project Name : D2577-5 Department Code:

Project Name : D2577-5 Department Code:
Project For : WK550 Burden Flags : NNNNNNN
Work Order Type : Main WO Status : Open

Main WO Number : Invoice State : Not Invoiced

House Part Number : D2577-5 Invoice Date :

Description : Wearplate, Centre Invoice Number :
Manufactured : Yes Invoice Amount : 0.00

Manufactured : Yes
Amount Req'd : 50

Amount Done : 0 Order Entry No :

Start Date : 11-18-05 OE Value : 0.00

Est Finish Date : 12-15-05

Act Finish Date : Est Margin : 0.000% Drawings Reqd : No Actual Margin : 0.000%

Ok for Approval : Approval Rec'd :

\$0 Posted to Finished Goods

		Estimated	Actual	Var. %	Posted	To Post
Material Cost	:	0.00	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00		
Engineering Cost	:	0.00	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00		
Production Cost	:	0.00	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00		
Packaging Cost	:	0.00	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00		
OverHead Cost	:	0.00	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00		
CNC	:	0.00	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00		
Misc.	:	0.00	0.00	0.00	0.00	0.00
		=======				
Burden	:	0.00	0.00	0.00		
Total Cost	:	0.00	0.00	0.00		
Margin	:	0.000	0.000			
Selling Cost	:	0.00	0.00			

Estimated Actual Labour Hrs/Amount Done : 0.00 0.00 Profits/(Loss) : 0.00 0.00





New Agranus Steel Lemmus Gleenbrook, South Auskland Postak Private Beg 92121, Auskland, New Zealand Telephones: (09) 375 8995 / 375 8111 Auskland (09) 235 8099 / 235 3536 Waruku Fax; (09) 375 8859

## TEST CERTIFICATE

Ref: 5210/22495

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MILL ON	480737									-										PAGE		1	of 1	
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PACK NUMBER	HEAT No	C Si	Mn	P	s	Cu	Ni	Cr	Mo 1	/ Nb	Ti	Ai	B N2	CE( )	BEND	YIELD	T.S.	%ELONG	HARDNESS		$\neg r$		***********	
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YIELO (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS (B)=50mm

: GAUGE LENGTH (G.L.) ; (A)=200mm

(C)=80mm (D)=5.65 ? So

PLASTIC STRAIN RATIO (r) (E)=2" (F)=8" (A)=r0 (B)=r90

IMPACT TEST (C)=r45 (A)=10mm x 10mm (D)=(r0+r90+2r45) / 4 (B)=7.5mm x 10mm

(C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm

CARBON EQUIVALENT VALUE (CE)

(A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15

(C)=C+Mn/6+Si/24 (D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED Satish Misra QC METALLURGIST

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(T80.6)

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MATERIAL TEST/INSPECTION CERTIFICATES

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INSPECTION CERTIFICATE 9023916

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New Zestand Steet Limited Glenbunck, Sauth Auckland Postat: Private Bag 92121, Auckland, New Zestand Tolephones: (09) 375 899 / 375 8111 Auckland (09) 235 8089 / 235 3535 Weisku Fas: (09) 375 8559

## TEST CERTIFICATE

Reissued 22/8/2005

Ref: 5279/23650

١			L		CHEMICAL COMPOSITION PERCENT											MECHANICAL TESTS (TEST SPECIFICATION - ASTMA379									)			
ļ	PACK NUMBER		C	Si	Mn	P	S	Cu	Ni	G	Mo	V	Nb	Tì	Ai	8 N	2 C	E( )	BEND	YIELD	T.S.	%ELONG	HARDNESS		.	LENGTH	100	
1		HEAT No	x100							x1000						x10000 x100		180*		•	G.L.=	HRB	(	)	(feet)		_ }	
1	<b>R9-466080</b> -00	845423	6	TR	21	11	16	17 :	20	16	2	3	1	3	, T	1	1		Gnod				50			2700		
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YIELD	GAUGE LEN	GTH (G.L.)		PLASTIC S	TRAIN RATIO (r)	IMPACT TEST	(C)≠5mm x 5mm	CARBON EQUIVALENT VALUE (CE)		
(A)=0.2% PROOF STRESS	(A)=200mm	(C)=80mm	(E)=2"	(A)=(0	(C)=r45	(A)=10mm x 10mm	(D)=2.5mm x 10mm	(A)=C+Mn/6	(C)=C+Mn/6+Si/24	
(B)=LOWER YIELD STRESS	(B)=50mm	(D)=5.65 ° So	(F)≈8"	(8)≃:90	(D)=(rQ+r9Q+2r45) / 4	(B)=7.5mm x 10mm	(E)=Smm x 10mm	(B)=C+Mn/8+(Cr+V+Mo)/5+(Cu+Ni)/15	(D)=	
						- •				

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED Anish Misra

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